

Date: Wednesday, 6/28/2006 4:17:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 STEP ASSEMBLY, SHORT HIGH SKID
Job Number : 27735	
Estimate Number : 10460	
P.O. Number : N/A	Part Number : D350591113
This Issue : 6/28/2006 S.O. No. : N/A	Drawing Number : D2310 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : D
Previous Run : 27307	Material : N/A
Written By : _____	Due Date : 8/25/2006 Qty: 12 Um: Each
Checked & Approved By : <u>06 06 29</u>	
Comment : Est Rev: H 04.11.09 Reformat KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

FF 06-07-28

2.0	D2244116	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2244 Step Extrusion B23404

FF 06-07-19

12

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

FF 06-07-19

12

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230

FF 06-07-19

12

3-Deburr

FF 06-07-19

12

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

06-07-20

12

5.0	D267334	End Plate
-----	---------	-----------

**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number: 27735

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2673-34

End Cap B25396

J.E. 06.07.21

12

6.0

D2275

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2275

Bushing B17557

J.E. 06.07.21

12

7.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part number

Description

Batch

1 D2582

Step-Leg Assembly

B25029-1 X5

B27756 X7

J.E. 06.07.21

12

8.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 192.0000 Each(s)

Pick:

Qty Part number

Description

Batch

16 MS20600AD4W3 Rivet

M14393

M14393

J.E. 06.07.21

12

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD Batch: M14393

2-Grind end cap and bottom bushing welds flush

3-Machine top weld on bushing flush

J.E. 06.07.24
PF 06.07.21 (12) (8)
FF 06.07.27 (12) (4)
LE 06.07.27
J.E. 06.07.22

12

12

12

10.0

QC5/9

WELD INSPECTION



Comment: WELD/WORK INSPECTION

J.E. 06.07.31 (12)
12/06/07/31 (12)

W/O: 0		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:15 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP ASSEMBLY, SHORT HIGH SKID

Job Number: 27735

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M.F. 06/07/31

(12)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

325089-1 = 2
327756 = 10

(195)

L.E. 06.8.1

12

2-Inspect for foreign object as per QSI 024

L.E. 06.8.2

12

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: M100760
M15689

L.E. 06.8.2

12

4-Grind end cap welds flush

L.E. 06.8.2

12

13.0

QC5/9

WELD INSPECTION



PD 06-03-03

(12)

Comment: WELD INSPECTION

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

SC 06/08/09 (1)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PL 06/08/10 (6)
SC 06/08/10 (6)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



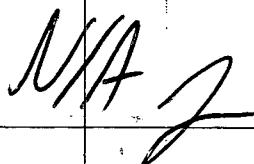
Comment: HAND FINISHING RESOURCE #1


Wing Walk as per Dwg D2310 and QSI 005 4.4

Batch: M 101667

SC 06/08/10 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
		102582 Screw with hole out of tolerance, not from drawing, but not in spec Assembly.						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/08/27

NOTE: Date & initial all entries

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Job Number: 27735

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*open
5 bars min.*



*5
06/02/22*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

K591113

Short Step Instn Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

827760

06/02/16

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206108116

(12)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location: *REV H*

RB 06/08/16 / 06/08/21 (3)

22.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.22

Job Completion



C206108122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. 0 SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

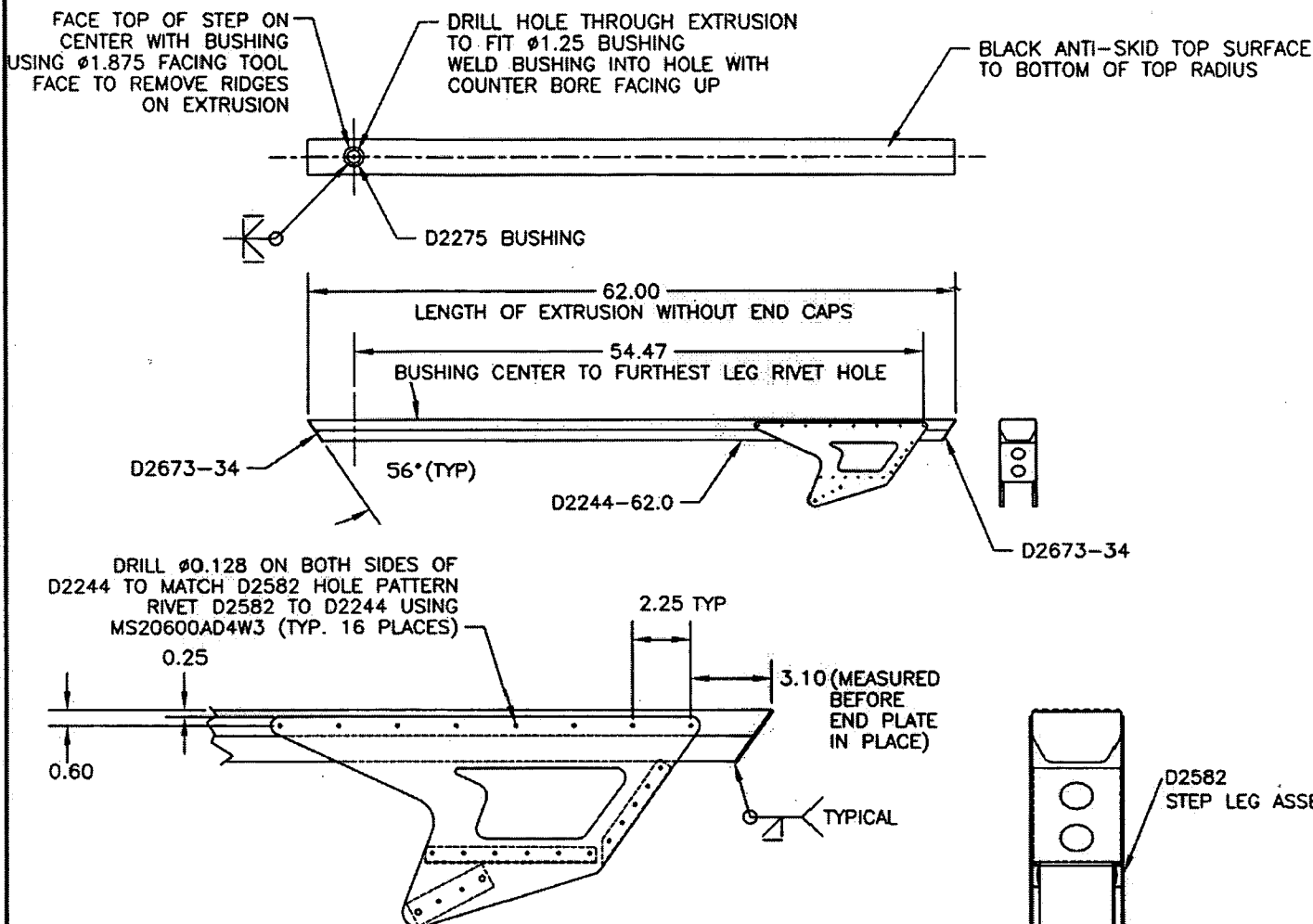
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DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. D
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH SHORT STEP ASSEMBLY	SCALE N/S	



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 2310

WORK ORDER

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